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D2281

Job Sheet 198496



Part No: D2281

Job Qty: 40 pcs

Part Name: Jack Saddle



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/30/19

Job Tracking No:

Due Date: 9/16/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV G IPP Rev:A Removed from 9 Digit 05-12-02 JLM IPP: rev B

Ship Via:

## Bill of Materials

## Job Routing

| Op No | Operation                  | Qty       | Start Date | Due Date | Standard  |         | Workcenter/Supplier         |           | Sign-off    |
|-------|----------------------------|-----------|------------|----------|-----------|---------|-----------------------------|-----------|-------------|
|       |                            |           |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier       | Lead Time |             |
| 100   | Waterjet - Flow - 1        | 40<br>pcs |            | 9/16/19  | 0.17      | 2.10    | Waterjet - Flow             |           | 02/19/08/02 |
| 120   | QC 8                       | 40<br>pcs |            | 9/16/19  | 0.00      | 0.00    | QC 8 - 12                   |           |             |
|       |                            |           |            |          |           |         | QC 8 - 14                   |           |             |
|       |                            |           |            |          |           |         | QC 8 - 17                   |           |             |
|       |                            |           |            |          |           |         | QC 8 - 20                   |           |             |
|       |                            |           |            |          |           |         | QC 8 - 25                   |           |             |
|       |                            |           |            |          |           |         | QC 8 - 3                    |           |             |
|       |                            |           |            |          |           |         | QC 8 - 32                   |           |             |
|       |                            |           |            |          |           |         | QC 8 - 33                   |           |             |
|       |                            |           |            |          |           |         | QC 8 - 35                   |           |             |
|       |                            |           |            |          |           |         | QC 8 - 39                   |           |             |
|       |                            |           |            |          |           |         | QC 8 - 4                    |           |             |
|       |                            |           |            |          |           |         | QC 8 - 44                   |           |             |
|       |                            |           |            |          |           |         | QC 8 - 45                   |           |             |
|       |                            |           |            |          |           |         | QC 8 - 49                   |           |             |
|       |                            |           |            |          |           |         | QC 8 - 58                   |           |             |
|       |                            |           |            |          |           |         | QC 8 - 8                    |           |             |
|       |                            |           |            |          |           |         | QC 8 - 9                    |           |             |
|       |                            |           |            |          |           |         | QC 8 - 68                   |           |             |
|       |                            |           |            |          |           |         | QC 8 - 67                   |           |             |
|       |                            |           |            |          |           |         | QC 8 - 1 (A)                |           |             |
|       |                            |           |            |          |           |         | QC 8 - 47                   |           |             |
|       |                            |           |            |          |           |         | QC 8 - 40                   |           |             |
|       |                            |           |            |          |           |         | QC 8 - 52                   |           |             |
|       |                            |           |            |          |           |         | QC 8 - 23                   |           |             |
|       |                            |           |            |          |           |         | QC 8 - 57                   |           |             |
| 140   | Small Fab - Brake NC - B4B | 40<br>pcs |            | 9/16/19  | 0.25      | 1.01    | Small Fab - Brake - 1 - B4B |           |             |
|       |                            |           |            |          |           |         | Small Fab - Brake - 2 - B4B |           |             |
|       |                            |           |            |          |           |         | Small Fab - Brake - 3 -     |           |             |

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|     |                             |           |         | B4B       |                        |
|-----|-----------------------------|-----------|---------|-----------|------------------------|
| 150 | QC 5                        | 40<br>pcs | 9/16/19 | 0.00 0.00 | QC 5 - 10              |
|     |                             |           |         |           | QC 5 - 12              |
|     |                             |           |         |           | QC 5 - 17              |
|     |                             |           |         |           | QC 5 - 18              |
|     |                             |           |         |           | QC 5 - 19              |
|     |                             |           |         |           | QC 5 - 22              |
|     |                             |           |         |           | QC 5 - 24              |
|     |                             |           |         |           | QC 5 - 3               |
|     |                             |           |         |           | QC 5 - 43              |
|     |                             |           |         |           | QC 5 - 49              |
|     |                             |           |         |           | QC 5 - 51              |
|     |                             |           |         |           | QC 5 - 58              |
|     |                             |           |         |           | QC 5 - 68              |
|     |                             |           |         |           | QC 5 - 9               |
|     |                             |           |         |           | QC 5 - 50              |
|     |                             |           |         |           | QC 5 - 30              |
|     |                             |           |         |           | QC 5 - 40              |
|     |                             |           |         |           | QC 5 - 61              |
|     |                             |           |         |           | QC 5 - 81              |
| 160 | Packaging 3-1 - Stock - B4B | 40<br>pcs | 9/16/19 | 0.00 0.00 | Packaging 3 - 1 - B4B  |
|     |                             |           |         |           | Packaging 3 - 2 - B4B  |
|     |                             |           |         |           | Packaging 3 - 3 - B4B  |
|     |                             |           |         |           | Packaging 3 - 4 - B4B  |
|     |                             |           |         |           | Packaging 3 - 5 - B4B  |
|     |                             |           |         |           | Packaging 3 - 6 - B4B  |
|     |                             |           |         |           | Packaging 3 - 7 - B4B  |
|     |                             |           |         |           | Packaging 3 - 8 - B4B  |
|     |                             |           |         |           | Packaging 3 - 9 - B4B  |
|     |                             |           |         |           | Packaging 3 - 10 - B4B |
|     |                             |           |         |           | Packaging 3 - 11 - B4B |
|     |                             |           |         |           | Packaging 3 - 12 - B4B |
|     |                             |           |         |           | Packaging 3 - 13 - B4B |
|     |                             |           |         |           | Packaging 3 - 14 - B4B |
|     |                             |           |         |           | Packaging 3 - 15 - B4B |
|     |                             |           |         |           | Packaging 3 - 16 - B4B |
|     |                             |           |         |           | Packaging 3 - 17 - B4B |
|     |                             |           |         |           | Packaging 3 - 18 - B4B |
|     |                             |           |         |           | Packaging 3 - 19 - B4B |
|     |                             |           |         |           | Packaging 3 - 20 - B4B |
|     |                             |           |         |           | Packaging 3 - 21 - B4B |
|     |                             |           |         |           | Packaging 3 - 22 - B4B |
|     |                             |           |         |           | Packaging 3 - 23 - B4B |
|     |                             |           |         |           | Packaging 3 - 24 - B4B |
|     |                             |           |         |           | Packaging 3 - 25 - B4B |
|     |                             |           |         |           | Packaging 3 - 26 - B4B |
|     |                             |           |         |           | Packaging 3 - 27 - B4B |
|     |                             |           |         |           | Packaging 3 - 28 - B4B |
|     |                             |           |         |           | Packaging 3 - 29 - B4B |
|     |                             |           |         |           | Packaging 3 - 30 - B4B |
|     |                             |           |         |           | Packaging 3 - 31 - B4B |
|     |                             |           |         |           | Packaging 3 - 32 - B4B |
|     |                             |           |         |           | Packaging 3 - 33 - B4B |
|     |                             |           |         |           | Packaging 3 - 34 - B4B |
|     |                             |           |         |           | Packaging 3 - 35 - B4B |
|     |                             |           |         |           | Packaging 3 - 36 - B4B |
| 170 | QC 21 - SA                  | 40<br>pcs | 9/16/19 | 0.00 0.00 | QC 21 - SA - 21        |
|     |                             |           |         |           | QC 21 - SA - 70        |
|     |                             |           |         |           | QC 21 - SA - 53        |

DAS  
40  
9-89

AUG 16 2019

Pk W co(-)

AUG 16 2019

Part Op **100** - 1-Cut as per Dwg Dwg Rev: 6 Prog Rev: 6 2-Deburr if necessary  
 Descriptions: **120** - (QC8- Inspect parts - second check)  
**140** - Form as per D2281 using D2281-T2  
**150** - (QC5- Inspect part completeness to step on W/O)  
**160** - (Identify as per dwg & Stock Location: \_\_\_\_\_) LOCATION : WA001-1  
**170** - (QC21- Final Inspection - Work Order Release)

**Job BOM**

| Part / Item | Component Name   | Quantity       | Operation               | Container |
|-------------|------------------|----------------|-------------------------|-----------|
| M304S14GA   | 304SS sheet .080 | 5 sf (.125 ea) | 100-Waterjet - Flow - 1 | S175152   |

**Job Allocations**

| Operation               | Component Part | Required | Inventory | Allocated |
|-------------------------|----------------|----------|-----------|-----------|
| 100-Waterjet - Flow - 1 | M304S14GA      | 5        | 38        | 0         |

**Part Specifications**

| Spec No | Description | Target/Tolerance               | Limits         | Type     | Special Comments |
|---------|-------------|--------------------------------|----------------|----------|------------------|
| 1       | Jack Saddle | 4.468Inches ± 0.010            | 4.478<br>4.458 |          |                  |
| 2       | Jack Saddle | 4.114Inches ± 0.010            | 4.124<br>4.104 |          |                  |
| 3       | Jack Saddle | 2.933Inches ± 0.010            | 2.943<br>2.923 |          |                  |
| 4       | Jack Saddle | 1.535Inches ± 0.010            | 1.545<br>1.525 |          |                  |
| 5       | Jack Saddle | 0.354Inches ± 0.010            | 0.364<br>0.344 |          |                  |
| 6       | Jack Saddle | 0.354Inches ± 0.010            | 0.364<br>0.344 |          |                  |
| 7       | Jack Saddle | 0.604Inches ± 0.010            | 0.614<br>0.594 |          |                  |
| 8       | Jack Saddle | 2.000Inches ± 0.010            | 2.010<br>1.990 |          |                  |
| 9       | Jack Saddle | 3.396Inches ± 0.010            | 3.406<br>3.386 |          |                  |
| 10      | Jack Saddle | 3.646Inches ± 0.010            | 3.656<br>3.636 |          |                  |
| 11      | Jack Saddle | 4.000Inches ± 0.010            | 4.010<br>3.990 |          |                  |
| 12      | Jack Saddle | 1.525Inches ± 0.010            | 1.535<br>1.515 |          |                  |
| 13      | Jack Saddle | 2.475Inches ± 0.010            | 2.485<br>2.465 |          |                  |
| 14      | Jack Saddle | 0.323Inches + 0.006<br>- 0.001 | 0.329<br>0.322 | Diameter |                  |
| 15      | Jack Saddle | 0.080Inches ± 0.010            | 0.090<br>0.070 |          |                  |

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Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                   |                                                                                                                                                                                                                                                                                                |                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                        |                                                                                                                                                                                                                                                  |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                         | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b>                                                                                                                                                                                                                                                                      |                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                        |                                                                                                                                                                                                                                                  |
|                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                   | Skid-tube <input type="checkbox"/><br>Machining <input type="checkbox"/><br>Large Fab <input type="checkbox"/>                                                                                                                                                                                 | Cross tube <input type="checkbox"/><br>Small Fab <input type="checkbox"/><br>Finishing <input type="checkbox"/>                                                                                                                                                                                                              | Eng. (Non-AW) <input type="checkbox"/><br>Prod. Eng. Coord. <input type="checkbox"/><br>Rec/Store/Packaging <input type="checkbox"/>                                                                                                                                                                   | Engineering <input type="checkbox"/><br>Water Jet <input type="checkbox"/><br>Supplier <input type="checkbox"/><br>Quality <input type="checkbox"/>                                                                                              |
| Date :                                                                                                                                                                                                                                                                                                                                                                                   | Sequence #:                                                                                                                       | QTY Affected :                                                                                                                                                                                                                                                                                 |                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                        | MRB (QSI042)                                                                                                                                                                                                                                     |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   | Disposition                                                                                                                                                                                                                                                                                    |                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                        | Completed By                                                                                                                                                                                                                                     |
|                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                   |                                                                                                                                                                                                                                                                                                |                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                        | Lead hand / Supervisor                                                                                                                                                                                                                           |
|                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                   |                                                                                                                                                                                                                                                                                                |                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                        |                                                                                                                                                                                                                                                  |
|                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                   |                                                                                                                                                                                                                                                                                                |                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                        | QC / QA Coordinator                                                                                                                                                                                                                              |
| <b>Root Cause</b><br><br>Operator <input type="checkbox"/><br>Manufacturing Process <input type="checkbox"/><br>Equip/Tooling <input type="checkbox"/><br>Handling/Presservation <input type="checkbox"/><br>Material <input type="checkbox"/><br>Product Improvement <input type="checkbox"/><br>Process Improvement <input type="checkbox"/><br>Human Factors <input type="checkbox"/> |                                                                                                                                   | <b>FAULT CATEGORY</b>                                                                                                                                                                                                                                                                          |                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                        |                                                                                                                                                                                                                                                  |
|                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                   | <input type="checkbox"/> Pressure/Forced<br><input type="checkbox"/> Bending<br><input type="checkbox"/> Crushing<br><input type="checkbox"/> Cracks<br><input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br><input type="checkbox"/> Marks/Chatter<br><input type="checkbox"/> Mislabeled | <input type="checkbox"/> Contamination<br><input type="checkbox"/> Misaligned/off center<br><input type="checkbox"/> BOM/Route<br><input type="checkbox"/> Broken/Damage/Defect<br><input type="checkbox"/> Incomplete/Unclear Instructions<br><input type="checkbox"/> Drill Holes<br><input type="checkbox"/> Fit/Function | <input type="checkbox"/> Power Loss/Surge<br><input type="checkbox"/> Folio/Program<br><input type="checkbox"/> Grain Direction<br><input type="checkbox"/> Weld<br><input type="checkbox"/> Wrong Stock Pulled<br><input type="checkbox"/> Out of Sequence<br><input type="checkbox"/> Off-set/Set-up | <input type="checkbox"/> Positioned Wrong<br><input type="checkbox"/> Outside Tolerance<br><input type="checkbox"/> Drawing<br><input type="checkbox"/> Finish<br><input type="checkbox"/> Part Lost/Missing<br><input type="checkbox"/> Misread |
|                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                   | Other/Details:                                                                                                                                                                                                                                                                                 |                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                        |                                                                                                                                                                                                                                                  |

**DART**  
AEROSPACE

Container No: S202681

Part: D2281

Job No: 198496

Serial No/Batch: S202681

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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